








# Work Order ID 63404


Thursday, October 28, 2010 4:17:25 PM

Page 1

Item ID:	D3238-15	Accept		Setup	Start	
Revision ID:						
Item Name:	Plate				Stop	
Start Date:	10/29/2010	Start Qty: 8.00		Cust Item ID:		
Required Date:	11/1/2010	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-10-28</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3238	Rev C								

100		FLOW WATER JET	0.00						
	Waterjet	<b>Memo</b>	0.00						
	FLOW CNC Waterjet	1-Cut as per Dwg D3238 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary							


B10-10-29

*E/S 10/10/29*

⑩

110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	<b>Memo</b>	0.00						
	Quality Control								

B10-10-29

120		QC8- Inspect parts - second check	0.00						
	QC	<b>Memo</b>	0.00						
	Quality Control								

*810/10/29*

⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3238-15

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 10/29/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 11/1/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 42

0.00



Packaging

Memo

0.00

Packaging



JL 10/10/29

10 0/

10/10/29 SP (102)

10/10/29 +10SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 63404**

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Page 3

Item ID: D3238-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 10/29/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/1/2010 Req'd Qty: 8.00



Customer:

Reference:

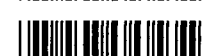
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 *[Signature]*  
R 10-10-29  
10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, October 28, 2010 4:17:25 PM

Page 1

Work Order ID: 63404



Parent Item: D3238-15



Parent Item Name: Plate


Start Date: 10/29/2010

Required Date: 11/1/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-10-20 EC  
IPP Rev:B Now on Waterjet 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.020  5052-H32 .020 Sheet		Purchased	No			100	sf	0.0000	0.012	0.101053			



10-10-29

103321

103321

10

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





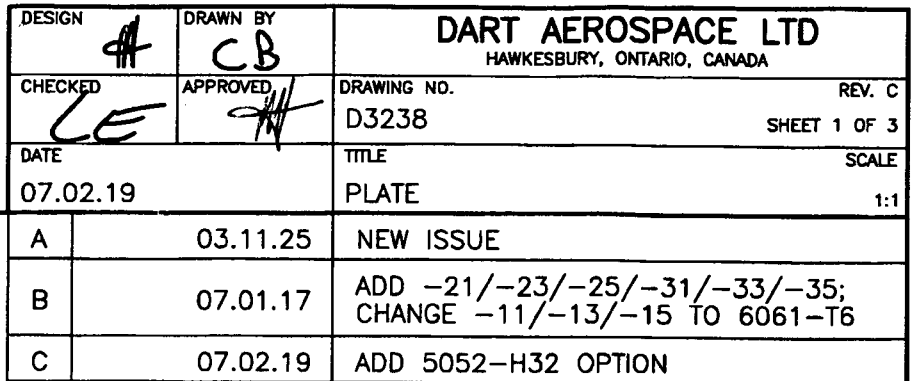
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

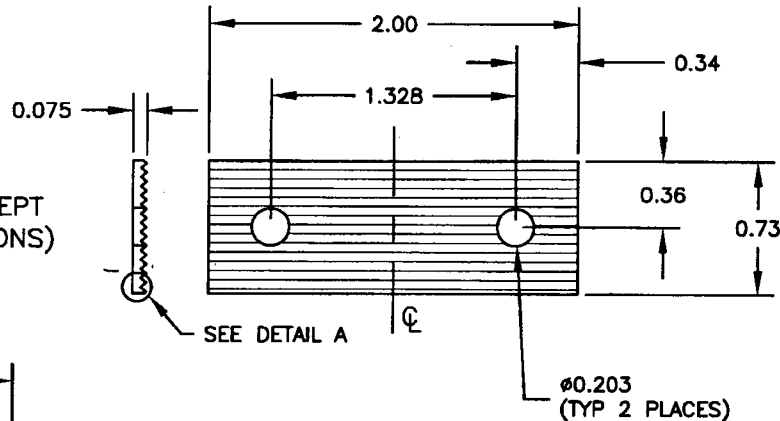
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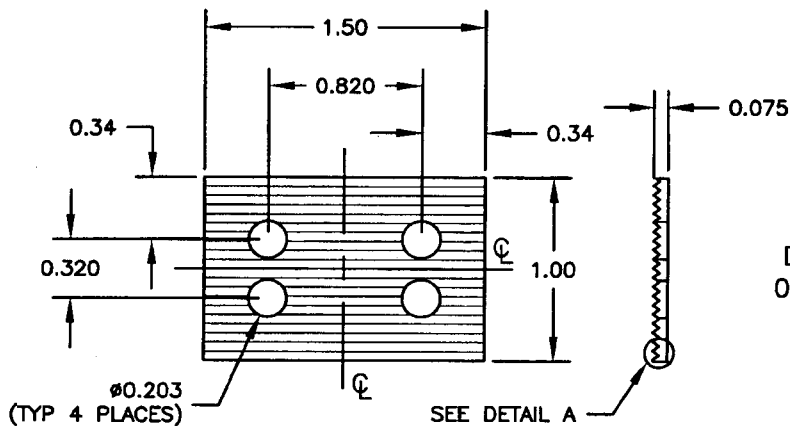


07.02.20

D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



# 63404



D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR  
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) SEE SHEET 3 FOR DETAIL A

7) PARTS ARE SYMMETRIC ABOUT  $\phi$

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

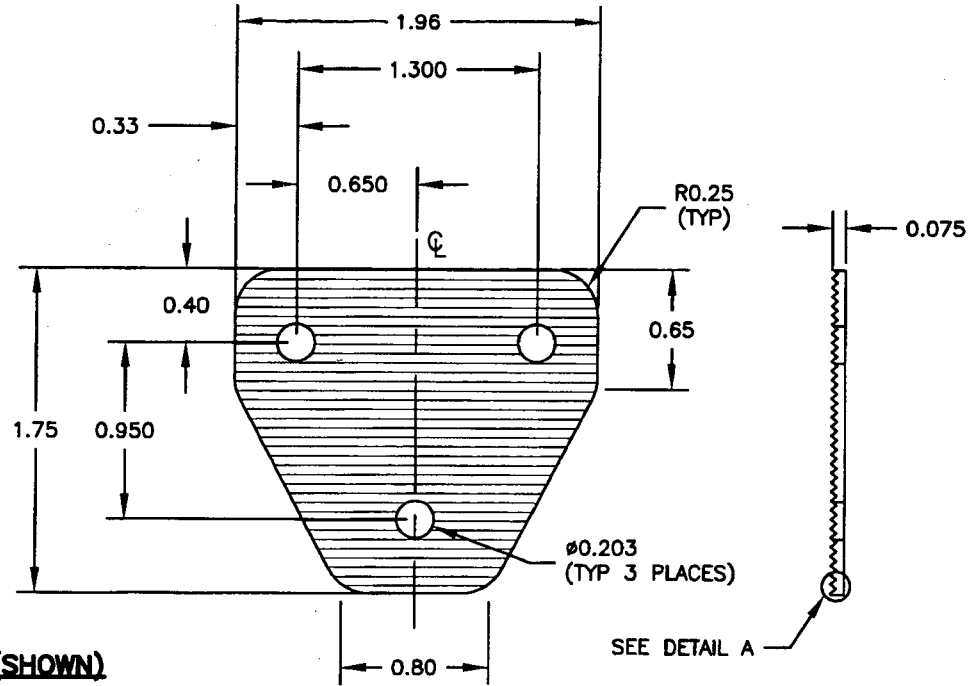
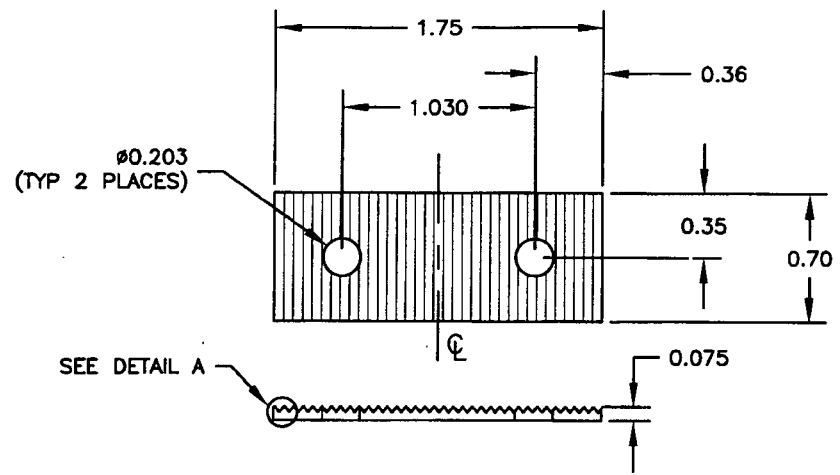
RELEASED

07.02.20

**D3238-5 PLATE (SHOWN)**

D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

#63409



**D3238-21 PLATE (SHOWN)**

D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

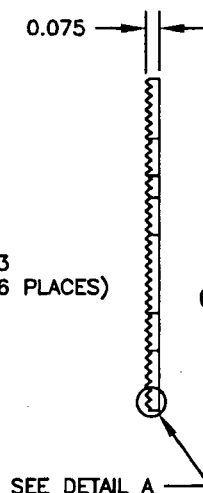
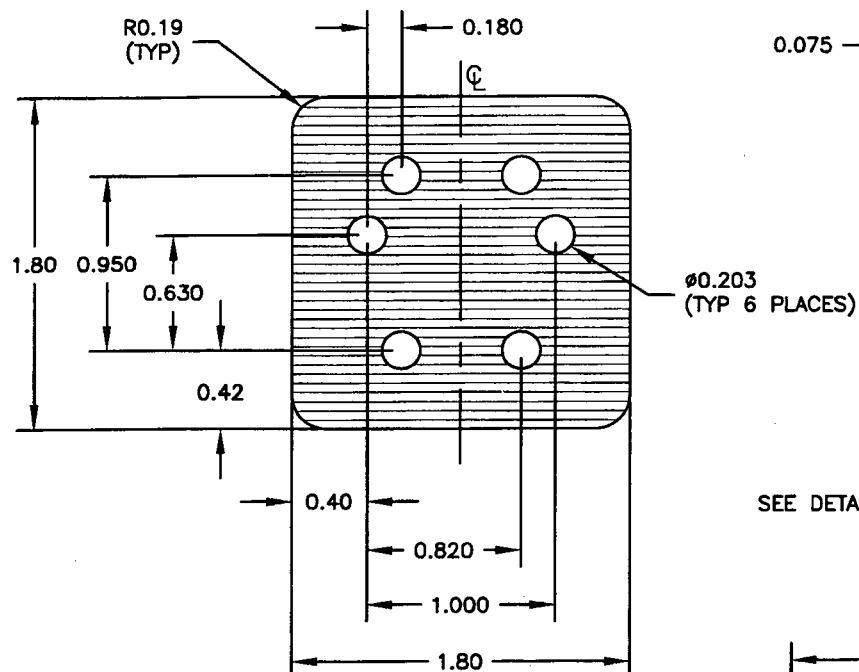
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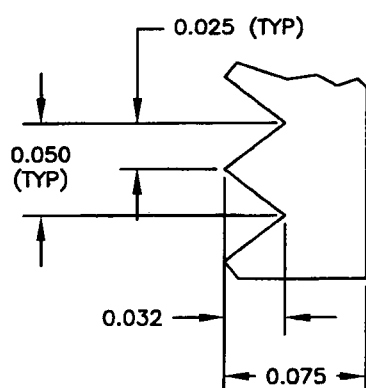
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



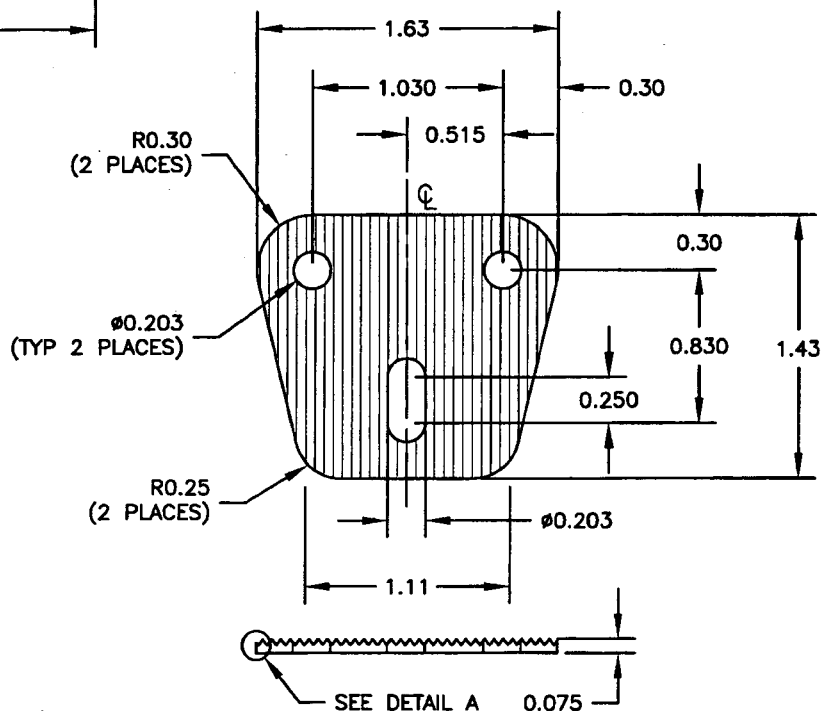
RELEASED  
07.02.20 #

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

#63404



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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